



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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D3574-6

Job Sheet 203390



Part No: D3574-6

Job Qty: 3 pcs

Part Name: Cabin Floor Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev :A New Issue 07.07.23 EC verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	3 pcs	11/29/19	11/29/19	0.17	1.18	Waterjet - Flow		11/19/27
110	QC 2	3 pcs	11/29/19	11/29/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		11/19/27
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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FG234

				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	3 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	Das 21
				QC 21 - SA - 70	Das
				QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D3574 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Deburr if necessary Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 150 - (Identify as per dwg & Stock Location: _____) 160 - (QC21- Final Inspection - Work Order Release)					DEC 02 2019
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MLEXS.125-F60029-04	GE Plastics Lexan Sheet (Dark Grey)	72 sf (24 ea)	100-Waterjet - Flow - 1	S165915	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	MLEXS.125-F60029-04	72	868	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order: 203390
Description: Cabin Floor Protector		Part Number: D3574-6
Inspection Dwg: D3574	Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø3.00	+0.006/-0.001	2.999	✓		Vim-42	
7.37	+/-0.030	7.37	✓		Type	
11.00	+/-0.030	11.00	✓			
15.25	+/-0.030	15.25	✓			
25.87	+/-0.030	25.87	✓			
39.75	+/-0.030	39.75	✓			
44.75	+/-0.030	44.75	✓			
58.38	+/-0.030	58.38	✓			
63.50	+/-0.030	63.50	✓			
65.25	+/-0.030	65.25	✓			
10.25	+/-0.030	10.25	✓			
11.87	+/-0.030	11.87	✓			
14.75	+/-0.030	14.75	✓			
26.00	+/-0.030	26.00	✓			
40.87	+/-0.030	40.87	✓			
45.00	+/-0.030	45.00	✓			
48.00	+/-0.030	48.00	✓			
55.13	+/-0.030	55.13	✓			
61.25	+/-0.030	61.25	✓			
61.88	+/-0.030	61.88	✓			
64.63	+/-0.030	64.63	✓			
1.13	+/-0.030	1.13	✓			
7.63	+/-0.030	7.63	✓			
11.00	+/-0.030	11.00	✓			
22.10	+/-0.030	22.10	✓			
22.50	+/-0.030	22.50	✓			
24.50	+/-0.030	24.50	✓			
35.13	+/-0.030	35.13	✓			
36.50	+/-0.030	36.50	✓			
40.00	+/-0.030	40.00	✓			
41.88	+/-0.030	41.88	✓			
43.63	+/-0.030	43.63	✓			
6.75	+/-0.030	6.75	✓			
9.50	+/-0.030	9.50	✓			

DART AEROSPACE LTD		Work Order:	
Description: Cabin Floor Protector		Part Number:	D3574-6
Inspection Dwg: D3574 Rev: B		Page 2 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.38	+/-0.030	10.38	1			
14.50	+/-0.030	14.50	1			
16.75	+/-0.030	16.75	1			
18.94	+/-0.030	18.94	1			
19.00	+/-0.030	19.00	1			
24.13	+/-0.030	24.13	1			
33.88	+/-0.030	33.88	1			
39.50	+/-0.030	39.50	1			
40.25	+/-0.030	40.25	1			
43.50	+/-0.030	43.50	1			
46.60	+/-0.030	46.60	1			
0.125	+/-0.010	0.131				

Measured by: <u>Dr</u>	Audited by: <u>DAS 40</u>	Prototype Approval:	N/A
Date: <u>19/11/27</u>	Date: <u>NOV 29 2019</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/DD	
B	09.05.15	Dimensions updated per Dwg Rev B	KJ <u>AG</u>	<u>AA</u>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

-DART
AEROSPACE

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Container No: S235257



Part: D3574-6

Job No: 203390

Serial No/Batch: S235257

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/27/19